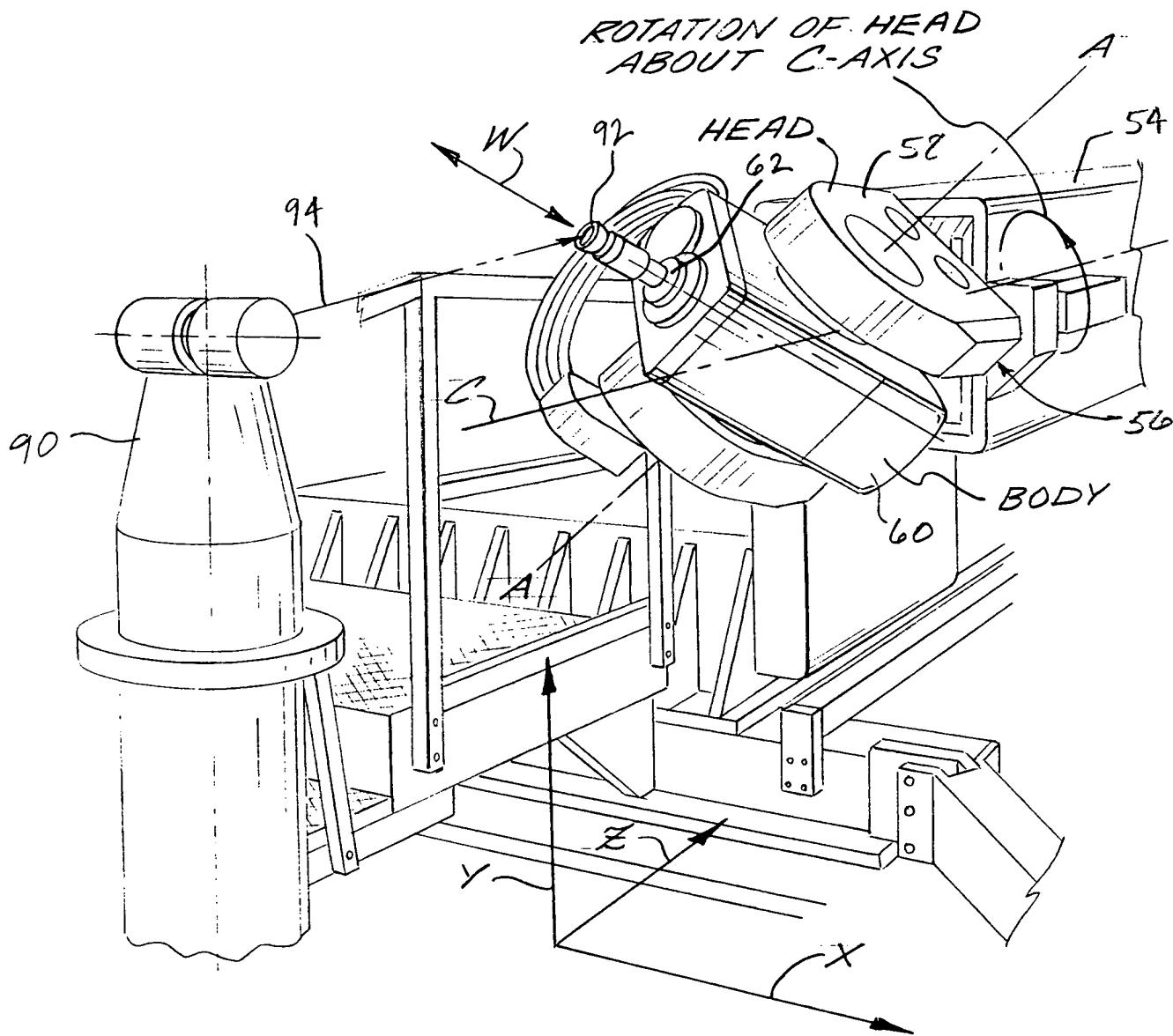
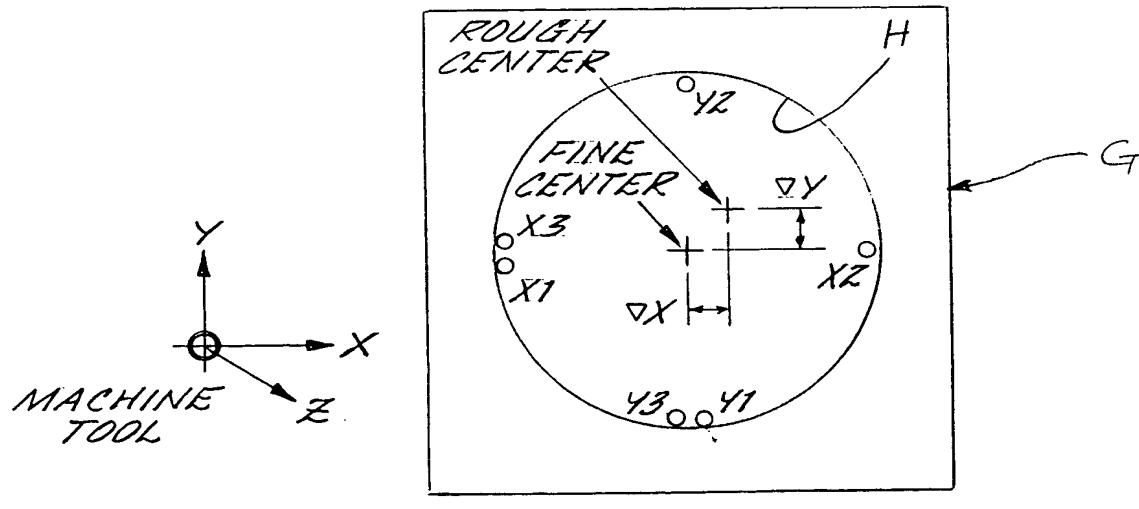
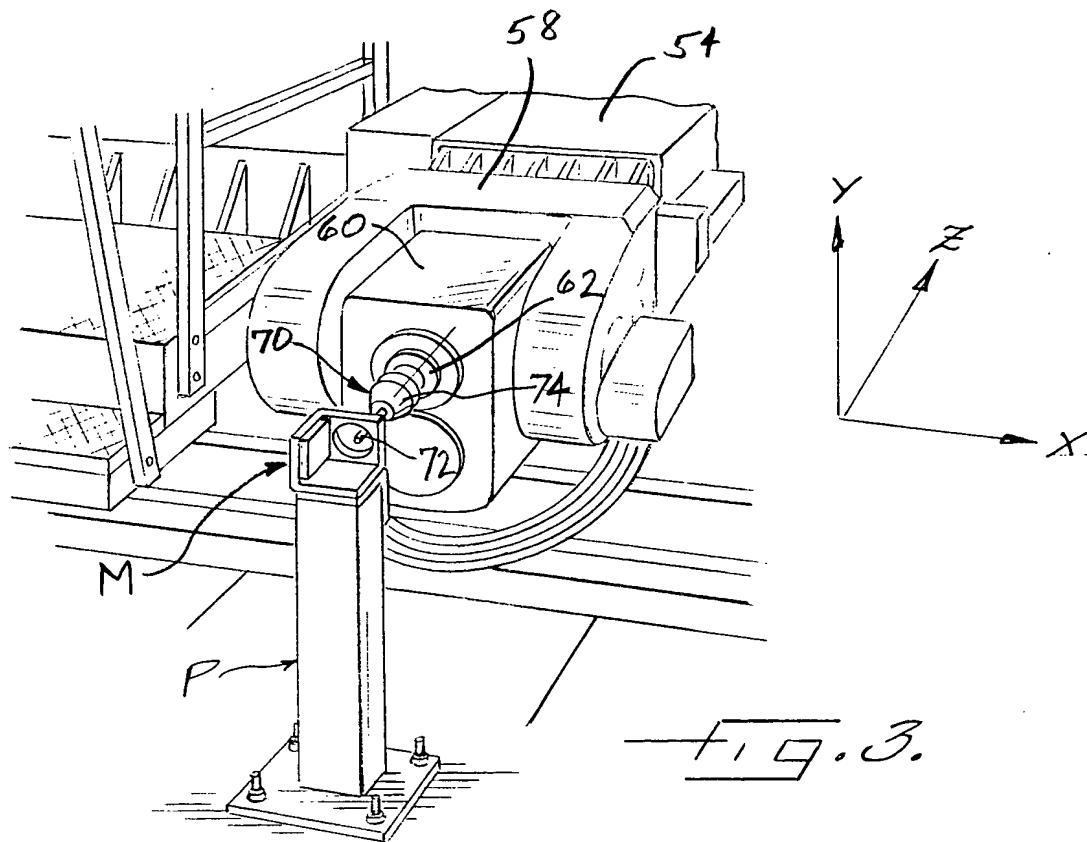


我已將你送回了。



BODY ROTATES WITH RESPECT
TO HEAD ABOUT A-AXIS

—Fig. 2.



C-AXIS ALIGNMENT

FIG. 4.

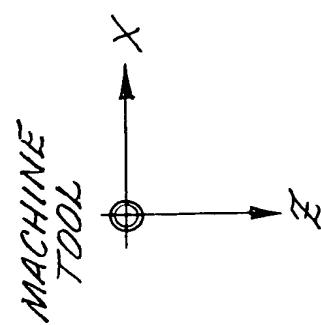
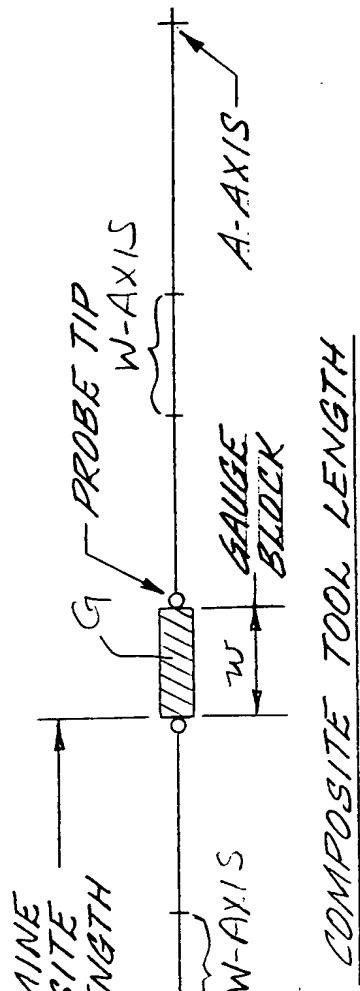
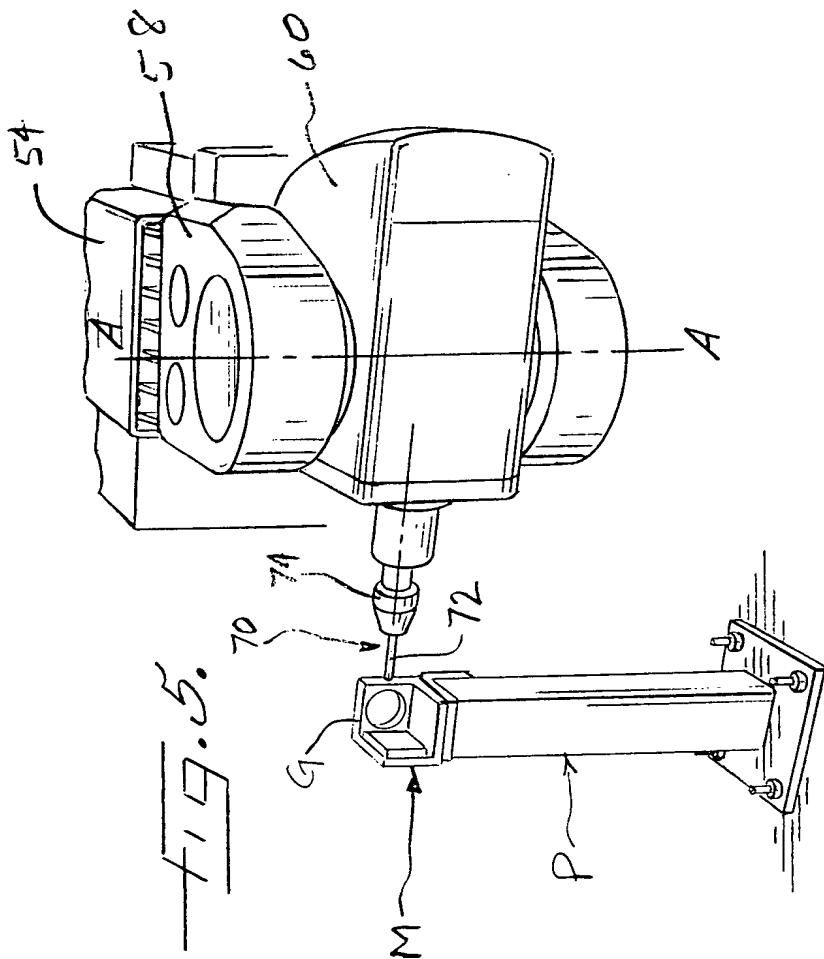
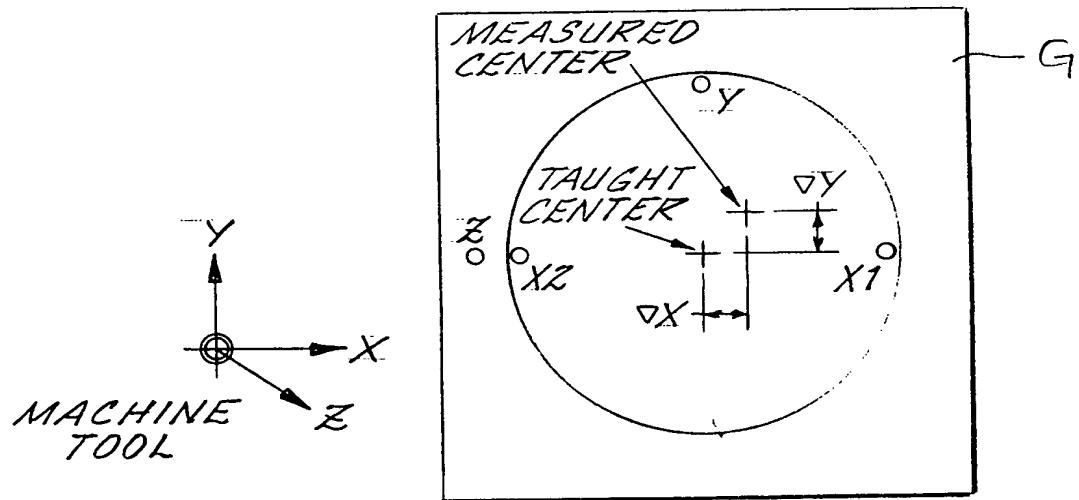
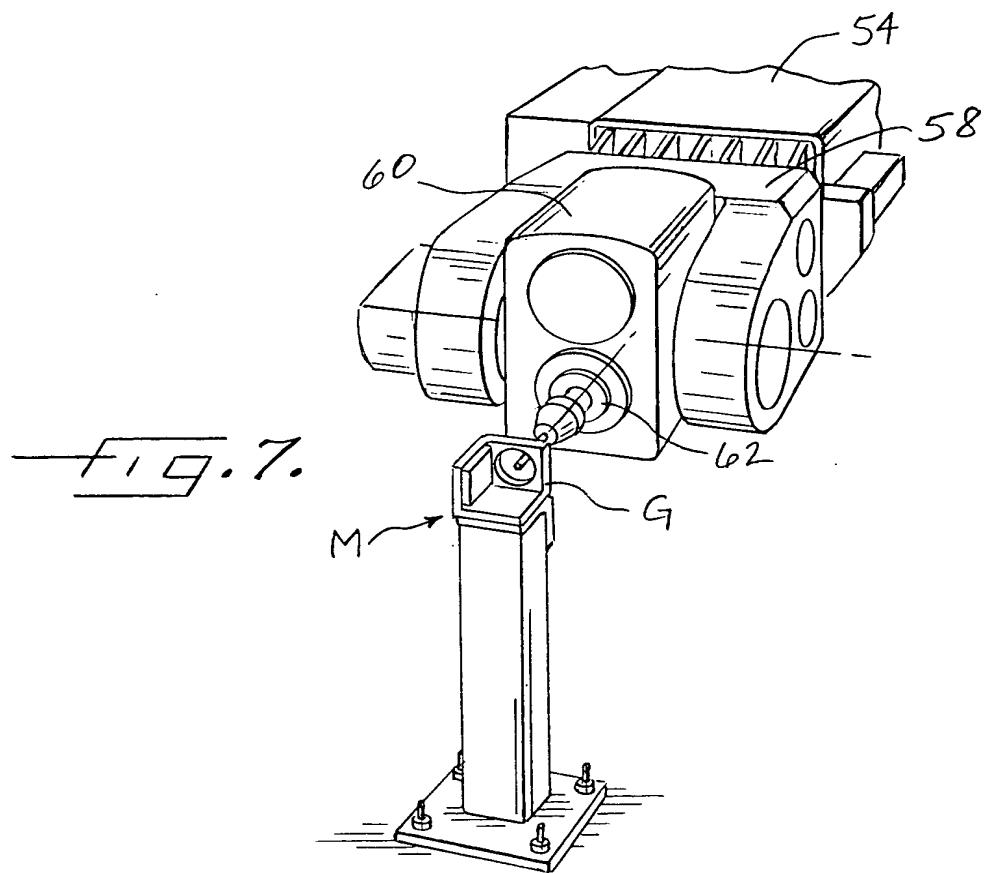


Fig. 6.



REPEATABLE POSITIONING OF MACHINE

FIG. 8.

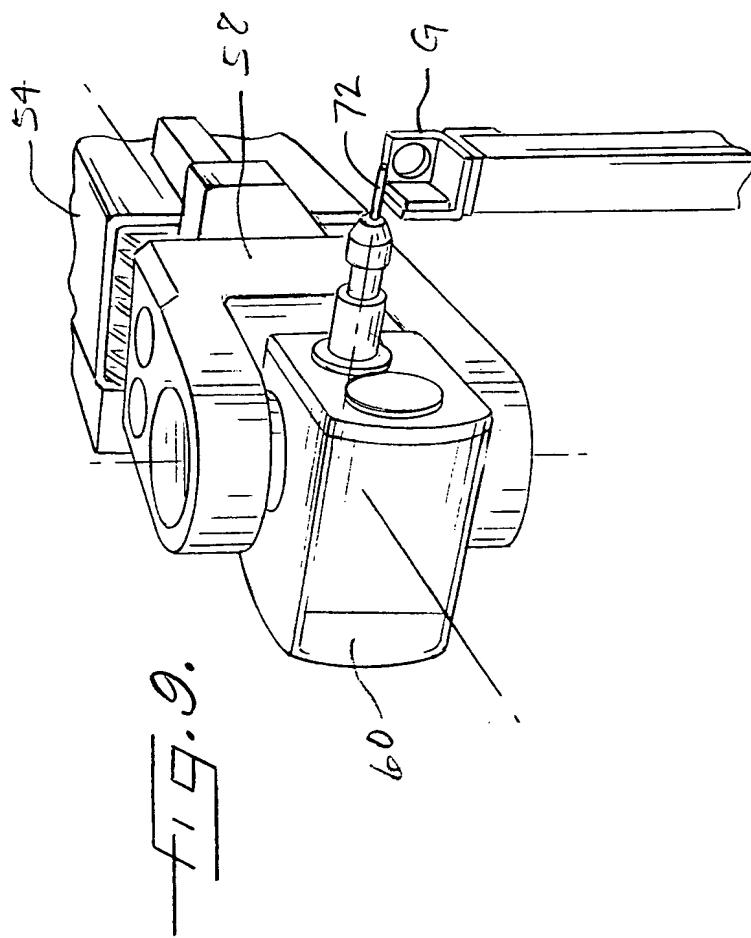


FIG. 9.

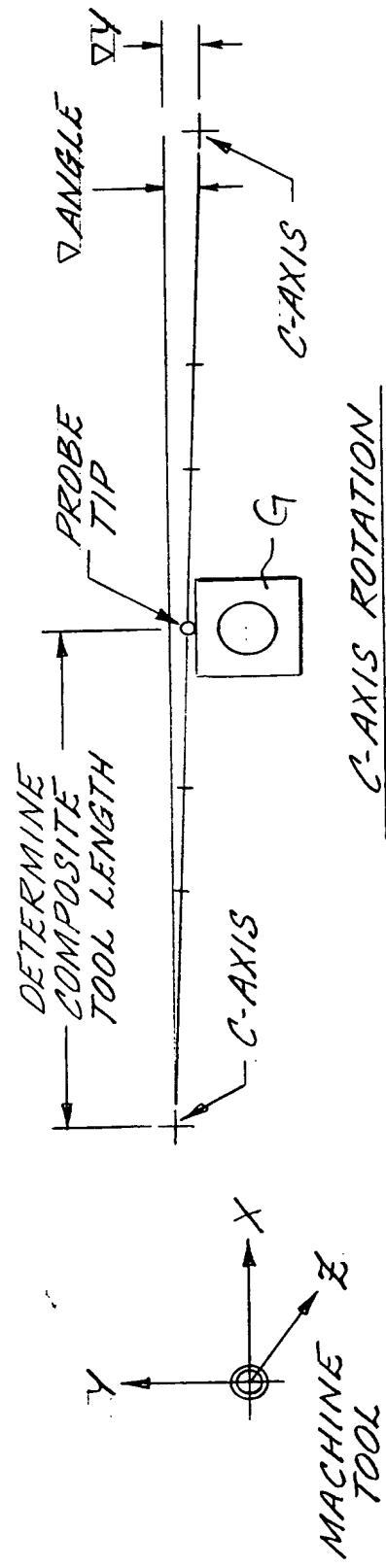
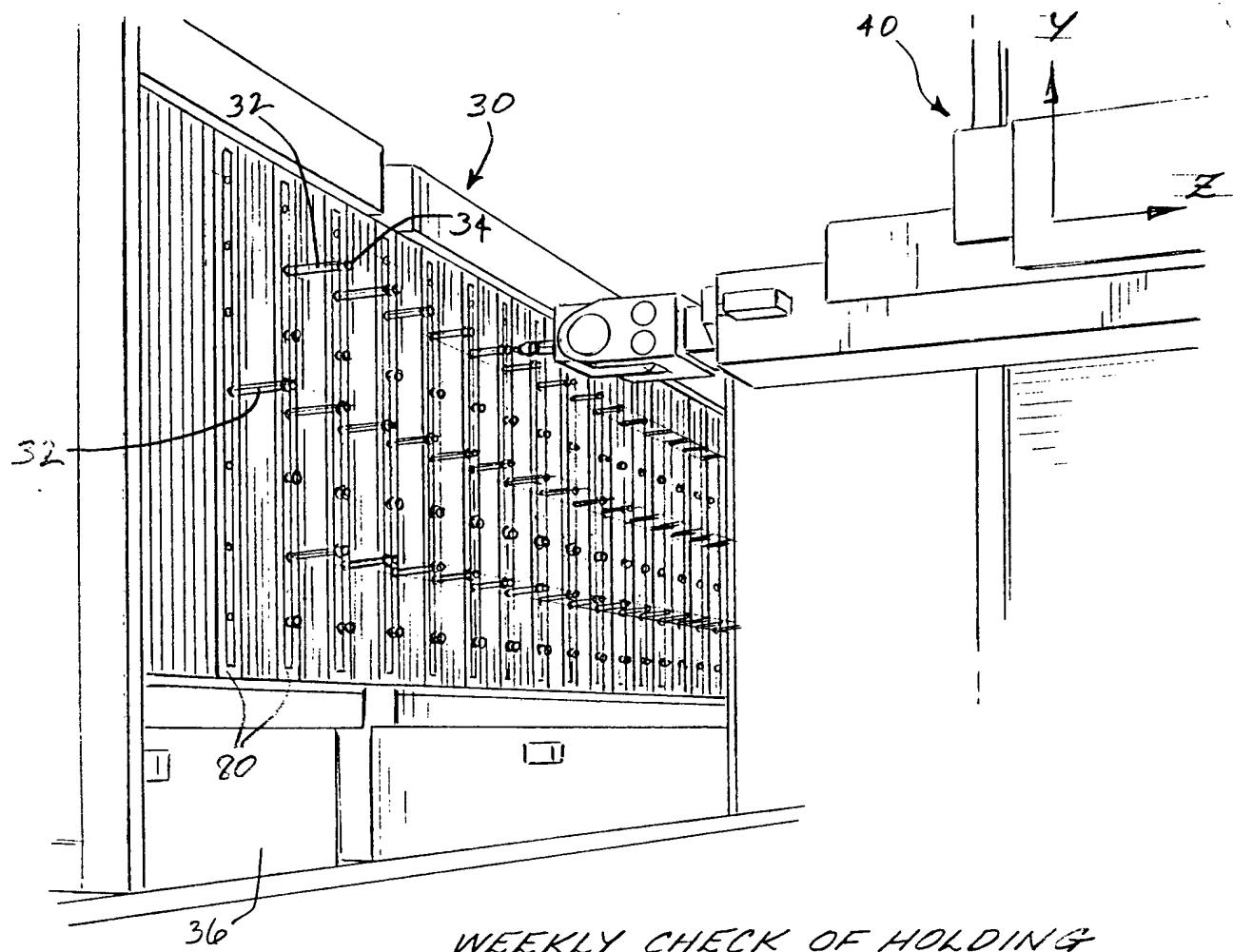
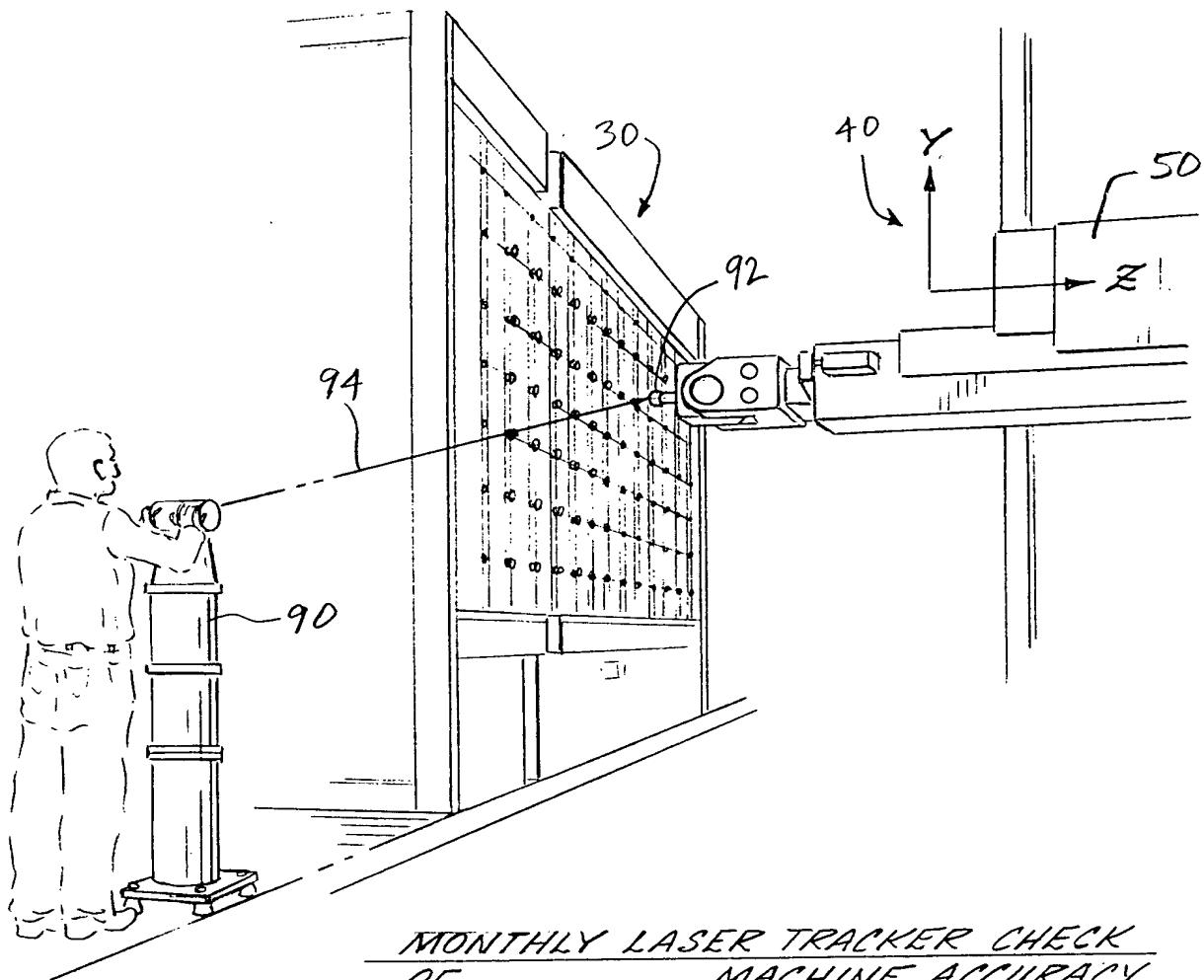


FIG. 10.



WEEKLY CHECK OF HOLDING
Fixture relative to the
MACHINE

FIG. 11.



MONTHLY LASER TRACKER CHECK
OF
MACHINE ACCURACY
ALONG X, Y, Z AXES

FIG. 12.

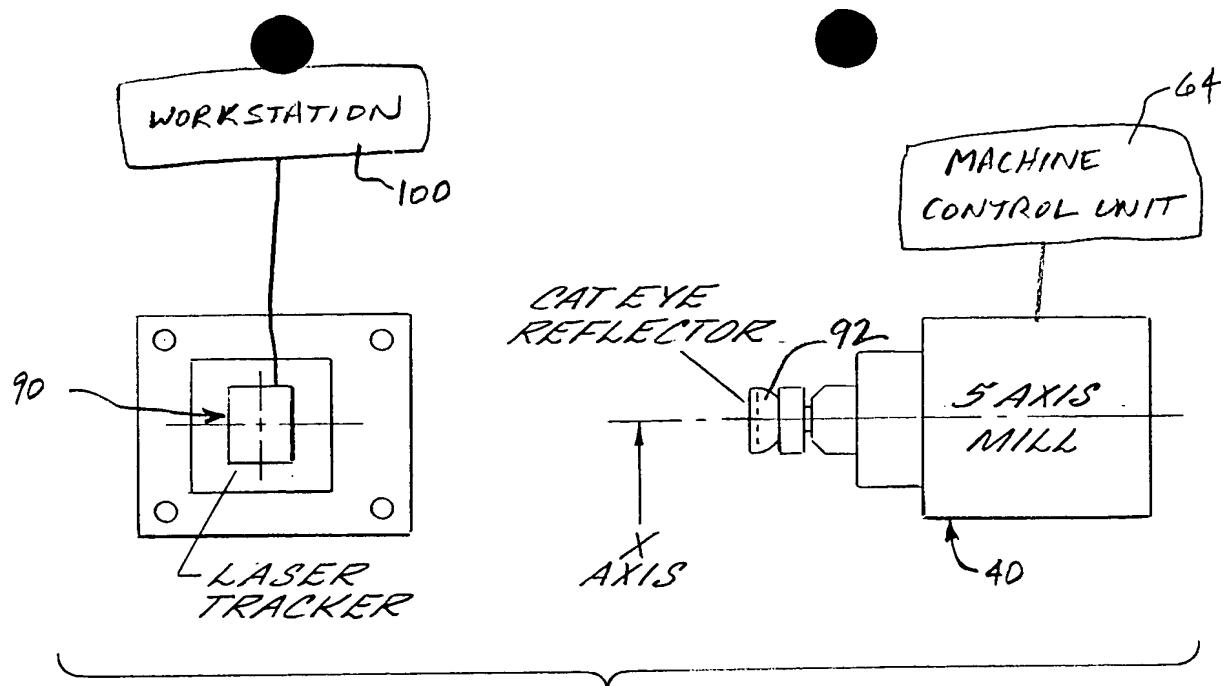


FIG. 13A.

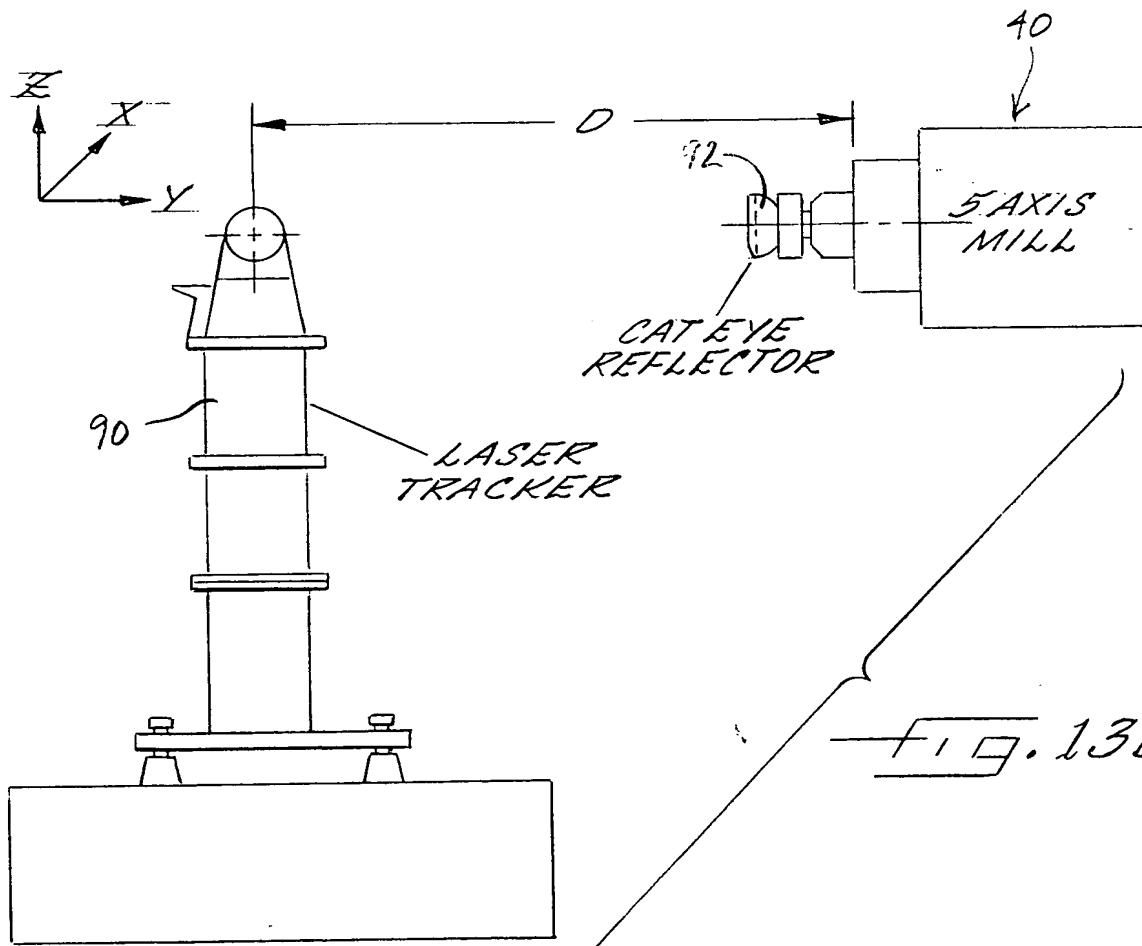
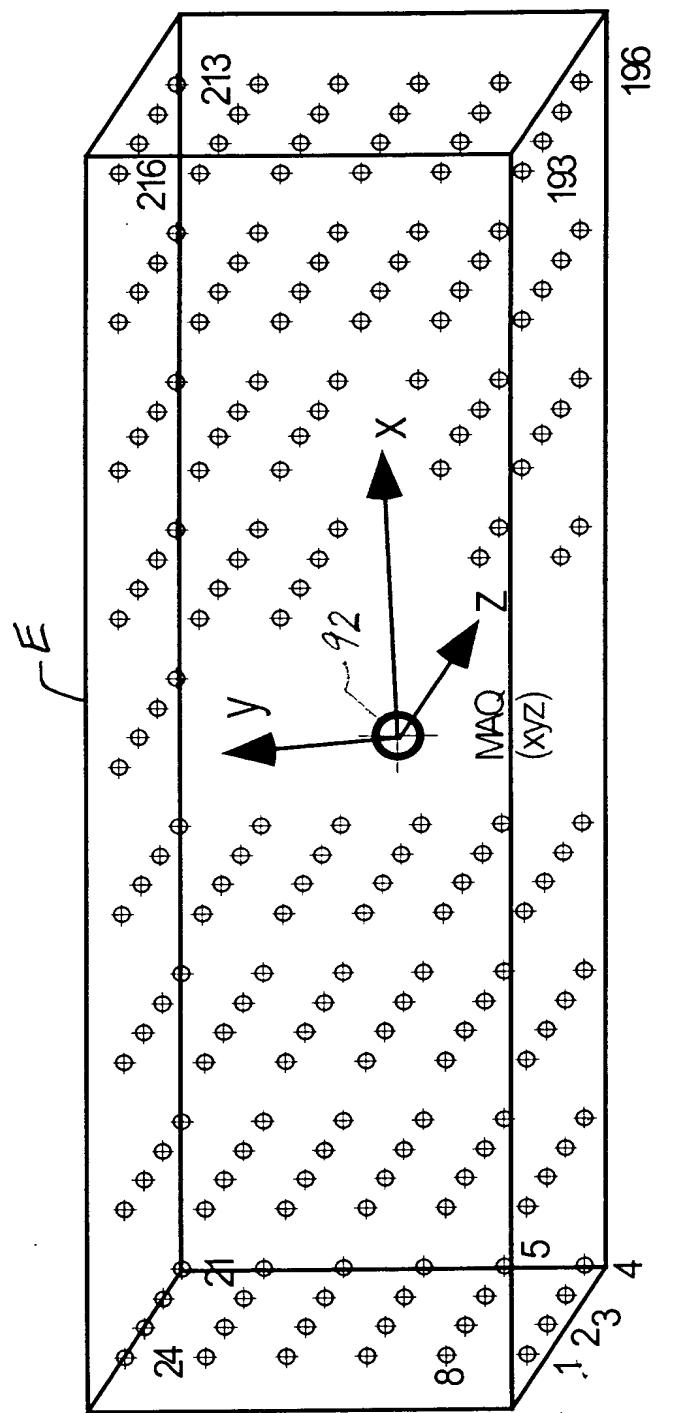


FIG. 13B.



Smart
310

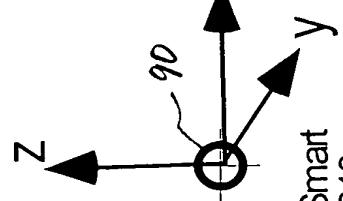


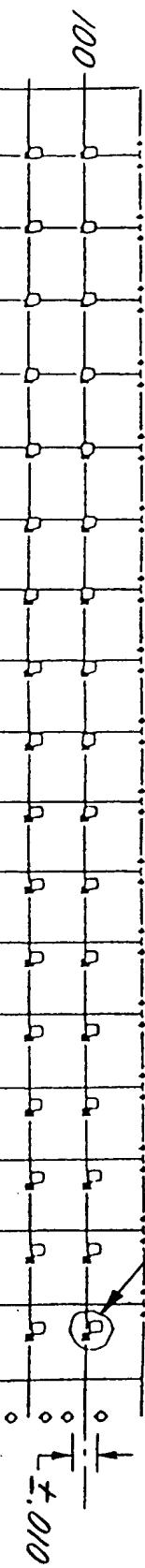
Fig. 14.

$X \pm Y$ TOLERANCE BAND
SHOWN = ± 0.010
(MAGNIFIED $\times 300$)

PLANE #4, $Z = 44.0$

ERRORS PORTRAYED WITH
MAGNIFICATION ($\times 300$)

± 0.010



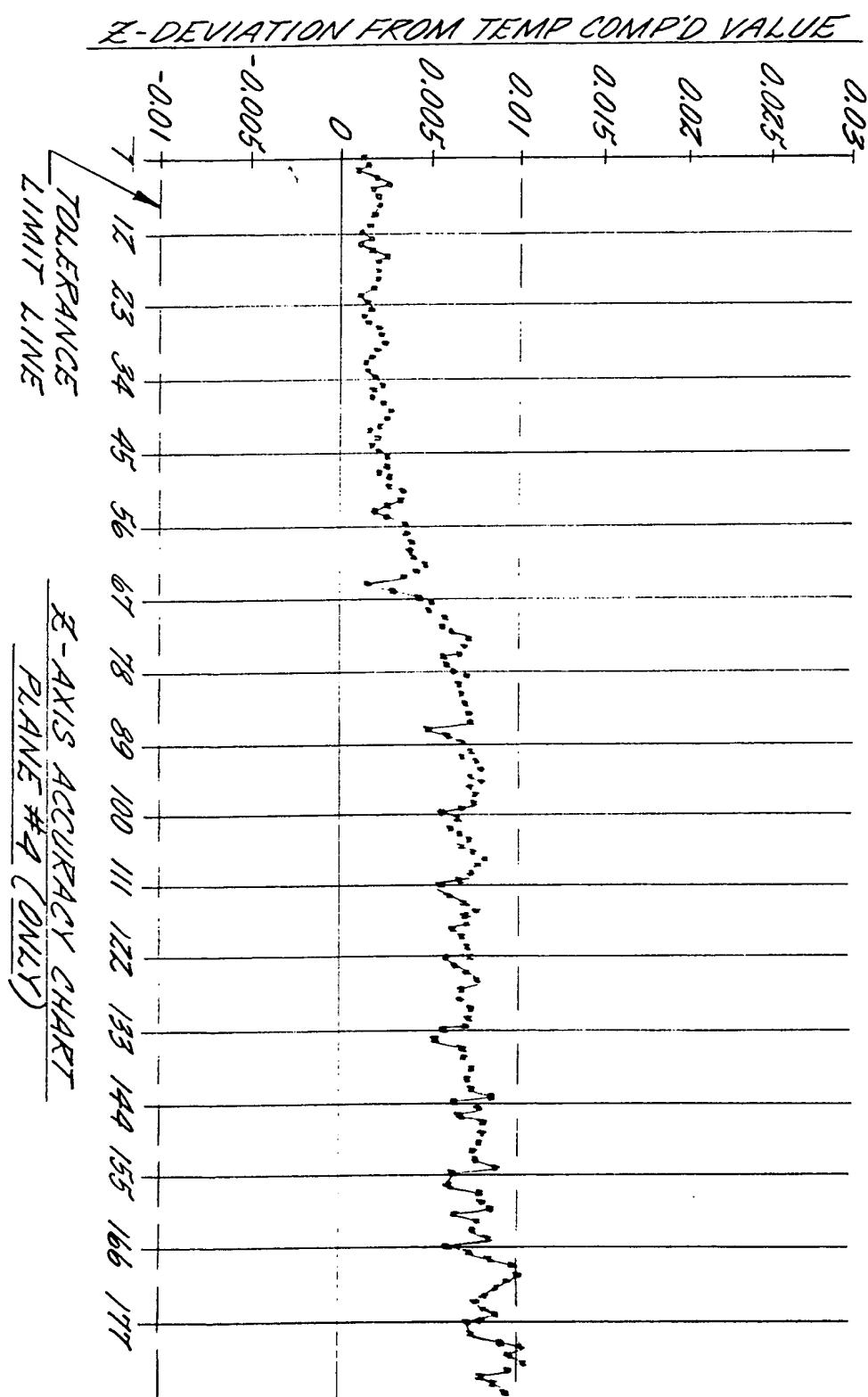
LOWER-LEFT CORNER OF
UHF WORK ENVELOPE

X-Y AXES ACCURACY
CHART

- MAGNIFIED INTENDED VALUES
- MAGNIFIED MEASUREMENTS
- X-AXIS TOLERANCE
- Y-AXIS TOLERANCE

— 15. 16.

PLANE #4, Z = 44.0



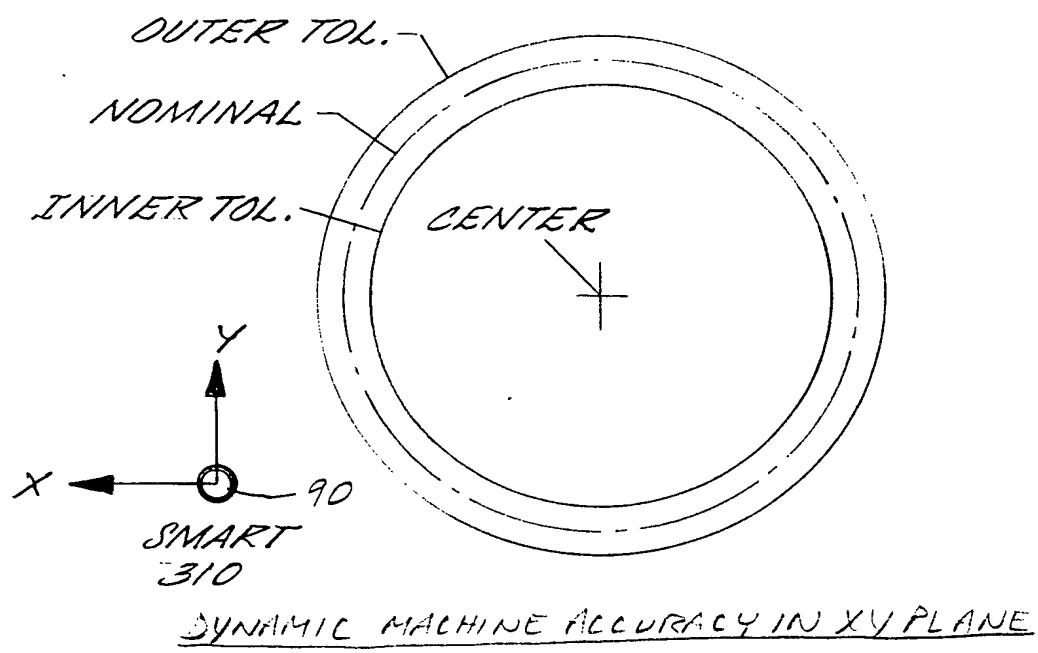
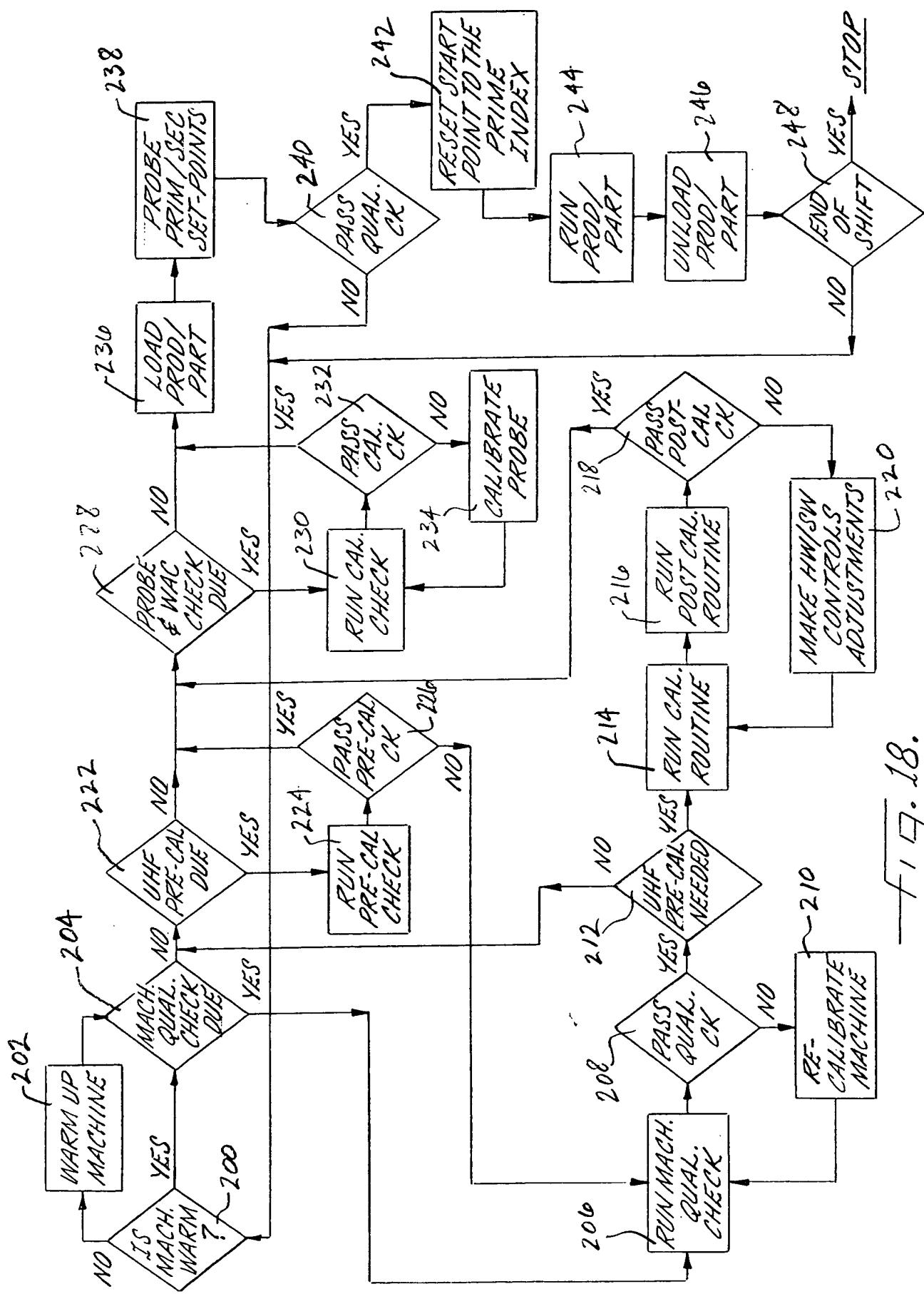


FIG. 15.



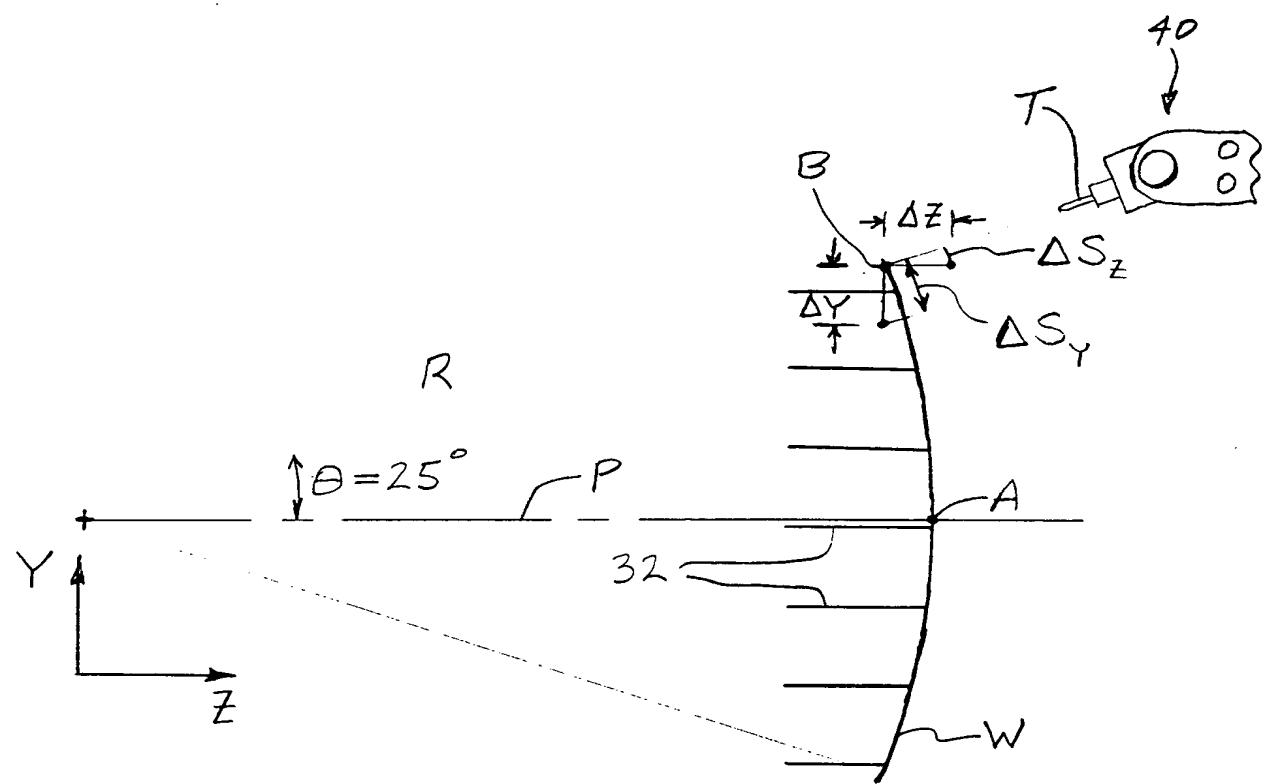


FIG. 19.

PARAMETER AFFECTING HOLE MISLOCATION	PARAMETER TOLERANCE (INCH)	ERROR CONTRIBUTION, ΔS_i (INCH)
POGO Y AND Z LOCATION	0.012	0.0071
FIXTURE SET POINT BLOCK Z ERROR	0.010	0.0042
C-AXIS OFFSET IN Y	0.003	0.0027
COMPOSITE TOOL LENGTH	0.005	0.0021
MACHINE Z ERROR	0.012	0.0101
MACHINE Y ERROR	0.012	0.0218
WAC AXIS Z ERROR	0.012	0.0051
WAC AXIS Y ERROR	0.005	0.0045
DELTA R BETWEEN POGOS	0.050	0.0120
PANEL ANGLE CHANGE EFFECT	1 DEGREE OVER 3 INCHES	0.0005
LOCATOR PIN ERROR	0.003	0.0027
DRILL C-AXIS OFFSET	0.002	0.0020
DRILL ENTRY WANDER	0.002	0.0020
	TOTAL ERROR, ΔS	0.0294

Fig. 20.